



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4073-1

Job Sheet 169724



Part No: D4073-1

Job Qty: 10 ea

Part Name: AW139 Door Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/20/17

Job Tracking No:

Due Date: 12/22/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/21/17	12/21/17	0.00	0.00	Start Up Machining-2		SBZ 18/01/22
100	Bandsaw	10 pcs	12/21/17	12/21/17	0.00	0.14	Bandsaw1		SBZ 18/01/22
105	CNC Vertical Machining	10 pcs	12/21/17	12/21/17	0.18	4.69	HAAS1-4		SBZ 18/01/22
120	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC8 Machining-2		SBZ 18-1-23
150	HandFinish	10 pcs	12/21/17	12/21/17	0.00	0.21	HandFinish1		25/01/23 2:05
160	Powdercoat	10 pcs	12/22/17	12/22/17	0.00	0.17	Powdercoat1		BK 18-01-23
170	QC	10 pcs	12/22/17	12/22/17	0.00	0.00	QC3		38
180	Packaging	10 pcs	12/22/17	12/22/17	0.00	0.00	Packaging3-2	Stom	25/01/23 2:05
190	QC21-SA	10 Ea	12/22/17	12/22/17	0.00	0.00	QC21		25/01/23 2:05

Part Op 100 - cut blank 4.563" long

Descriptions: 105 - Mill as per Dwg an Folio FA939

M 188467 START: 1:35 O.V. 1:300° FINISH: 2:05

JAN 2 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.000X01.250	4	21	0	0

~~4134 (10) (10)~~ →

SOC 8419 (10) → SOC 34117

SOC (10) 4*

DART
AEROSPACE
S034118



AW139 Door Hinge

PART NO: D4073-1
Original Serial #: S034118
Revision:
Operation: Start up Operation
Change No:

Dart Aerospace Ltd.

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01/22/18
Job No: 169724

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Hinge	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	,125
2	Door Hinge	0.203Inches $\pm$ 0.005 - 0.001	0.208 0.202	Diameter	,203
3	Door Hinge	2.000Inches $\pm$ 0.030	2.030 1.970		,1,993
4	Door Hinge	0.810Inches $\pm$ 0.030	0.840 0.780		,802
5	Door Hinge	0.350Inches $\pm$ 0.010	0.360 0.340		,346
6	Door Hinge	1.100Inches $\pm$ 0.010	1.110 1.090		,1,097
7	Door Hinge	0.500Inches $\pm$ 0.010	0.510 0.490	Diameter	,501
8	Door Hinge	0.125Inches $\pm$ 0.010	0.135 0.115		,125
9	Door Hinge	0.340Inches $\pm$ 0.010	0.350 0.330		,338
10	Door Hinge	1.320Inches $\pm$ 0.010	1.330 1.310		,1,318
11	Door Hinge	4.440Inches $\pm$ 0.030	4.470 4.410		,4,436
12	Door Hinge	4.130Inches $\pm$ 0.030	4.160 4.100		,4,124
13	Door Hinge	0.310Inches $\pm$ 0.030	0.340 0.280	Radius	,312
14	Door Hinge	0.313Inches $\pm$ 0.010	0.323 0.303		,313
15	Door Hinge	0.630Inches $\pm$ 0.030	0.660 0.600		,628
16	Door Hinge	1.000Inches $\pm$ 0.030	1.030 0.970		,994
17	Door Hinge	0.380Inches $\pm$ 0.030	0.410 0.350		,370
18	Door Hinge	0.190Inches $\pm$ 0.010	0.200 0.180		,191
19	Door Hinge	1.800Inches $\pm$ 0.030	1.830 1.770		,1,800
20	Door Hinge	0.250Inches $\pm$ 0.030	0.280 0.220		,257
21	Door Hinge	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	,125

Plex 1/9/18 10:38 AM dart.leroux.jason

SBL 18/01/22